

# Work Order ID 50918

July 24, 2009 4:09:35 PM



Page 1

Item ID: D3898-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector (206L)

Start Date: 07/27/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-07-24 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

30X51

M111588 BB 09/07/28 X3.

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9501  
Dwg Rev: A  
Folio Rev: A

BB 09/07/28 X3

(P70)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector	
09.08.12	W/O header	<del>D38</del> Add D3898 Rev. A to drug box.  perm change	EE	09.08.14		09.08.12	09.08.12	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB 09/08/05 X3

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Ph 09/07/30 X3

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

Ph 09/07/30 X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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July 24, 2009 4:09:35 PM



Page 3

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Start Date: 07/27/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

SL 09/07/30 (X3)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) S 09/08/06

(X3) 4

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

9/8/7 (3x) SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

05-08-12  
MF 09-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

July 24, 2009 4:09:35 PM

Page 1 / (

Work Order ID: 50918



Parent Item: D3898-1RevA



Parent Item Name: Floor Protector (206L)

Start Date: 07/27/2009

Required Date: 08/03/2009

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	600.0000	31.8000			



Lexan Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

600

111588

600

111588

BB

09/08/06

(x3)

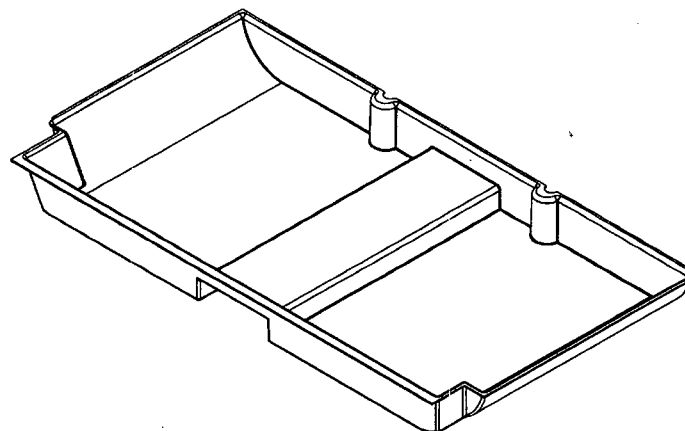
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**NOTE:** Date & initial all entries



#50918

**D3898-1 FLOOR PROTECTOR (206L)**

**RELEASED**  
29/06/08 MJD

**NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS
- 7) WEIGHT: 5.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3898	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	FLOOR PROTECTOR (206L)	NTS
DATE	09.02.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**Dart Aerospace Ltd**

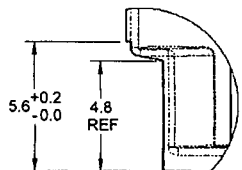
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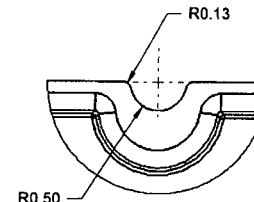
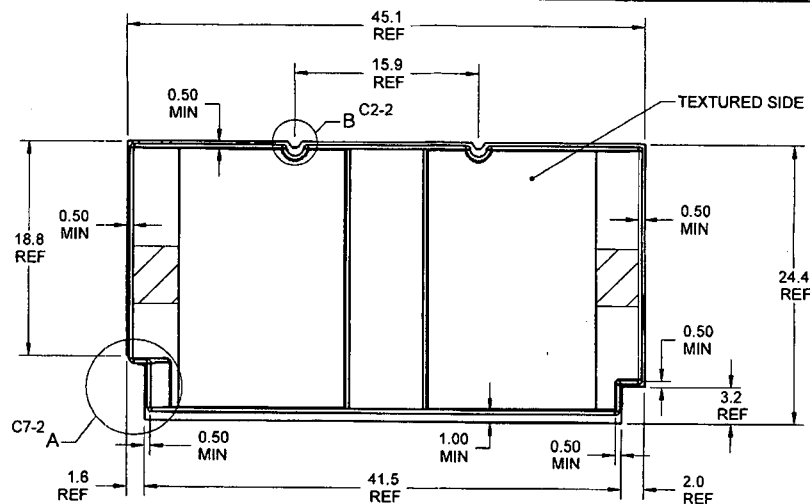
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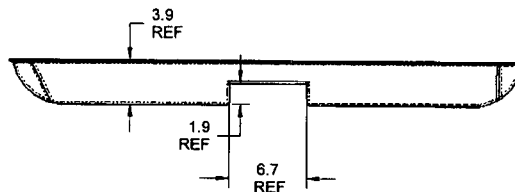
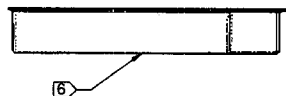
**NOTE:** Date & initial all entries



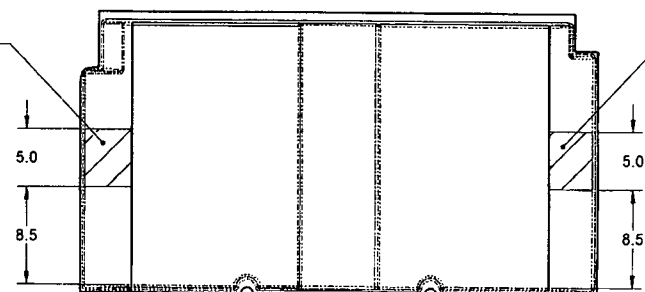
**DETAIL A** C6-2  
SCALE 2X



**DETAIL B** D5-2  
SCALE 5X  
2 PL



MIN THICKNESS  
0.080  
(SHADED REGION)



MIN THICKNESS  
0.080  
(SHADED REGION)

**D3898-1 FLOOR PROTECTOR (206L)**

#50918

**RELEASED**  
09/06/08 JH

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3898	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 2
APPROVED		FLOOR PROTECTOR (206L)	SCALE NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DATE	09.02.27	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

**Dart Aerospace Ltd**

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DART AEROSPACE LTD	Work Order: 50918
Description:	Part Number: D3898-1
Inspection Dwg: D3898-1 Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1/4"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	Date:
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50"	M.N	0.50"	✓			
1.00"	M.N	1.00"	✓			
5.6	+0.2 -0.2	5.75	✓			
0.080"	M.N -	0.101"	✓			
0.050"		0.075"	✓			

Measured by: [Signature]	Date: 09/07/30
Audited by: [Signature]	Date: 09/08/06
Prototype Approval: [Signature]	Date: 1/1

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	